

Date: Thursday, 11/23/2006 11:56:41 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 29681		
Estimate Number	: 10721		
P.O. Number	: N/A	Part Number	: D34637
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28195	Material	: N/A
Written By	: <u> </u>	Due Date	: 12/5/2006
Checked & Approved By	: <u> </u>	Qty:	6 Um: EACH
Comment	: EST REV A 05.11.18 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 1.0000 f(s)/Unit Total: 6.0000 f(s)
AISI 304 SS seamless tubing 0.750 OD X 0.120 wall
(M304TR0750W120)
Batch: 1101945

SAD 06:12:07

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Cut to 13.875"

SAD 06:12:07

⑥

2-Deburr

SAD 06:12:07

⑥

3-Bend end as per dwg D3463

SP

06/12/13

⑥

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06/12/14

⑥

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1-Mill as per dwg D3463

2-Drill hole as per dwg D3463

3-Deburr

JL / DSP 7/01/05

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-7 PAR #: N/A Fault Category: Prod / Machined NCR: Yes No DQA: 17 Date: 07/01/05
 QA: N/C Closed: 17 Date: 07.01.10

NCR: <u>29681</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/05	4.0	Dimension 0.550" is off by 0.090" on the hole; hole to close to the end.	<u>Q51042</u>	<u>Scrap. No replace</u>	<u>DSP</u> 07/01/05	<u>07-01-08</u>	<u>Q51042</u>	<u>07-01-08</u>

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 29681

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SLT DSP 07/01/05

5

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07.01.08

5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5183*

OP 07/01/09 (5) PC 7/01/09

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/10

Job Completion



07/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

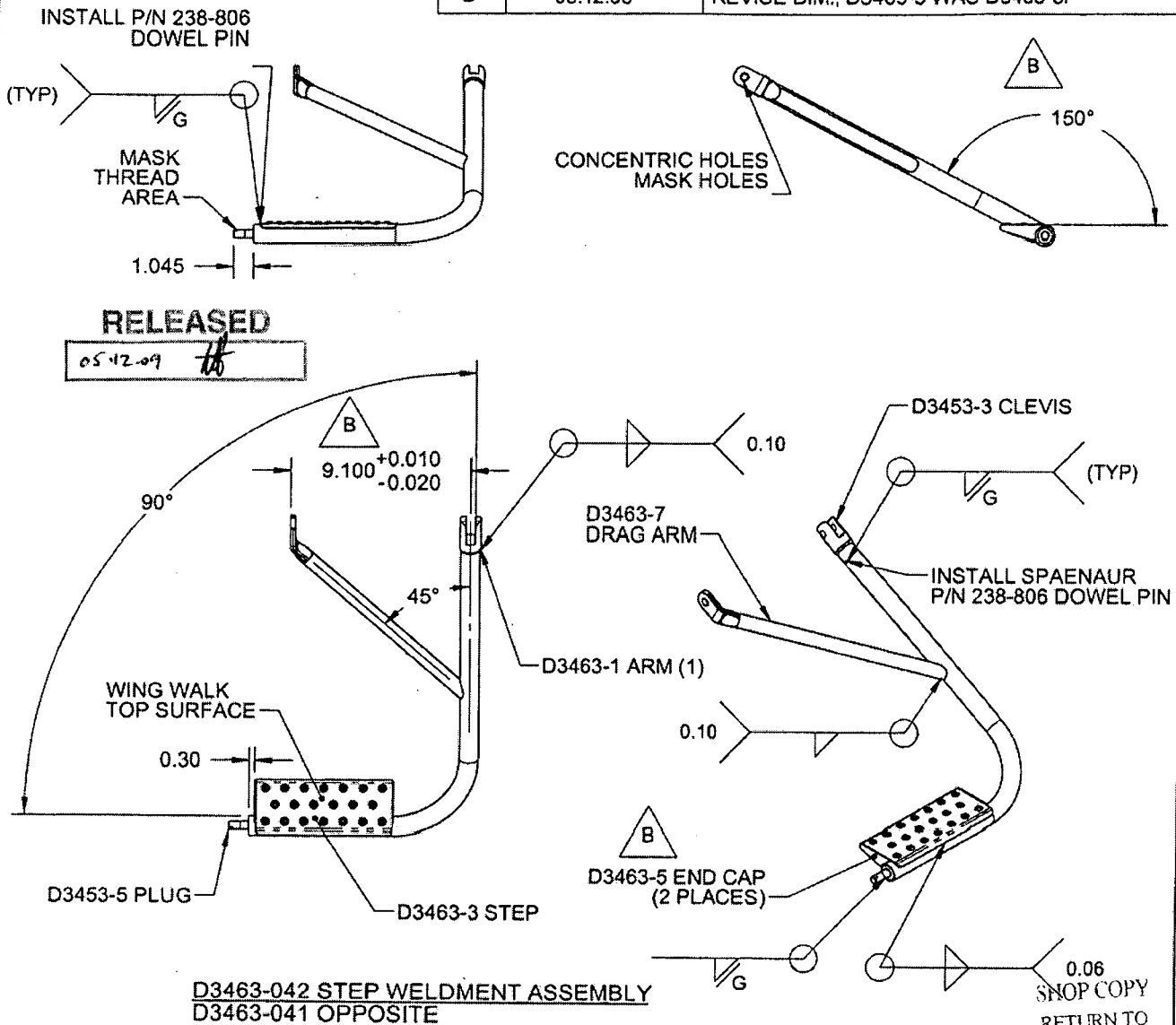
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

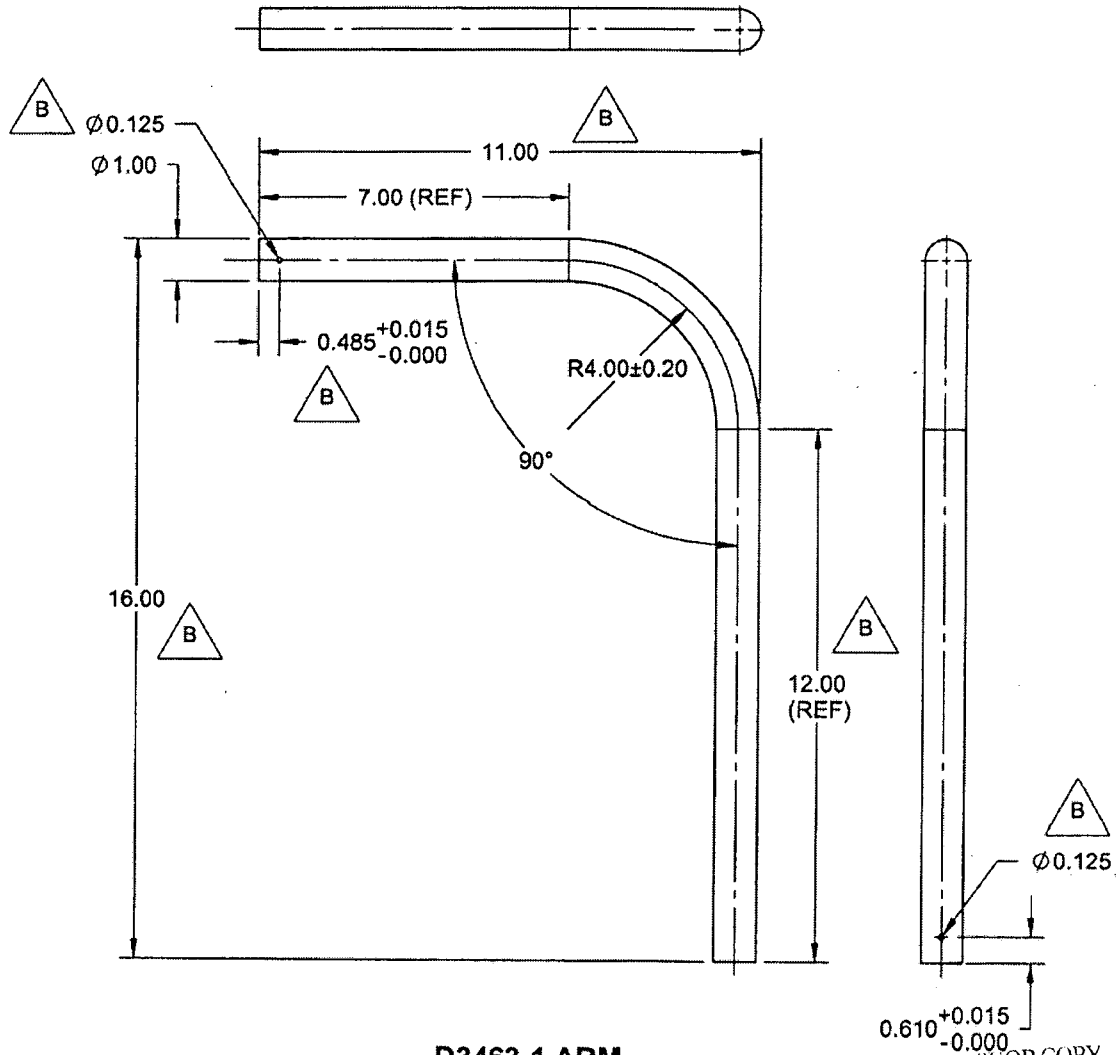
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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WORK ORDER
NO. **2968** 1

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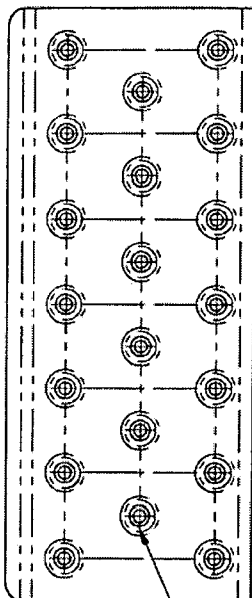
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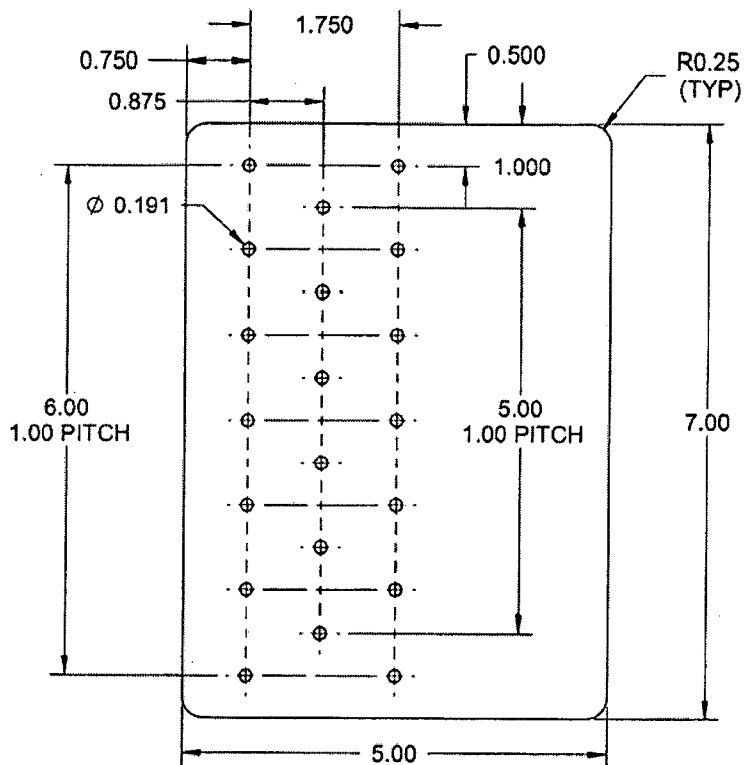
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

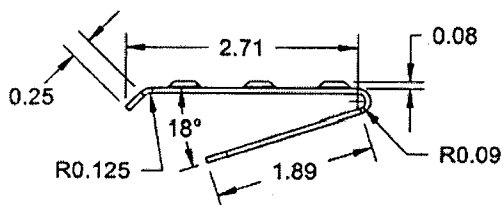
05.12.09 #



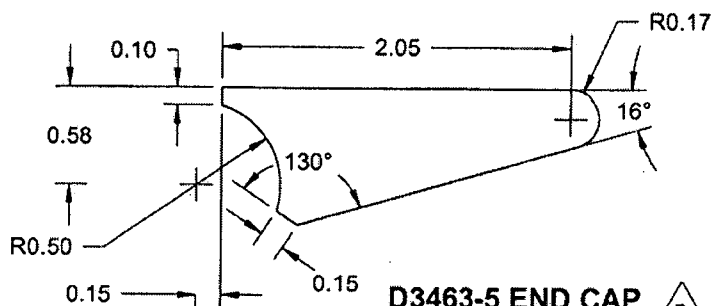
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO. 29681

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